

Date: Friday, 08/02/2008 9:12:39 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 37302
Estimate Number : 13167
P.O. Number :
This Issue : 08/02/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : LARGE FAB ASSY
Previous Run :
Written By :
Checked & Approved By :
Comment : Est Rev: A new issue 08-02-08 DD verified by: ec

Drawing Name : INSTRUMENT PANEL
Part Number : D3705044
Drawing Number : D3705
Project Number : N/A
Drawing Revision :
Material :
Due Date : 15/02/2008
Qty: 1 Um: Each

Handwritten notes: *FWAL 08.06.03*, *03705-043*, *08.05.03*, *Prototype*, *Prototype*, *POSITIVE*

Additional Product

PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

NA

2.0 D37051 MAIN PANEL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

MAIN PANEL

batch *B37293*

PD 08-02-08 (1)

3.0 D37053 COVER PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

COVER PLATE

batch *B37294*

PD 08-02-08 (1)

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Alum Rod Batch: M106330

1-Assemble as per dwg D3705 and weld as per QSI004

****nice weld all around and buff weld smooth***

PD 08-06-05

PD 08-02-08 (1)

5.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/06/05 (1)

3.1 D3706-1 Lock Bracket Qty: 1 Batch: *B05023*

3.2 D3706-3 Guide Qty: 1 Batch: *B05022*

08/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes- No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 08/02/2008 9:12:39 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL

Job Number: 37302

Part Number: D3705041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



08.06.05

Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08.02.20

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat ~~White Gloss~~ ^{Black} (Ref: 4.3.5.1) as per QSI 005 4.3

08.02.20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.06.05

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

08.02.20

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.05 Prototype
08/05/20

Job Completion



MF 08-05-16

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

W/O RE-CHECKED
TO ACCOMMODATE
LATEST REV.

08.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.02.07

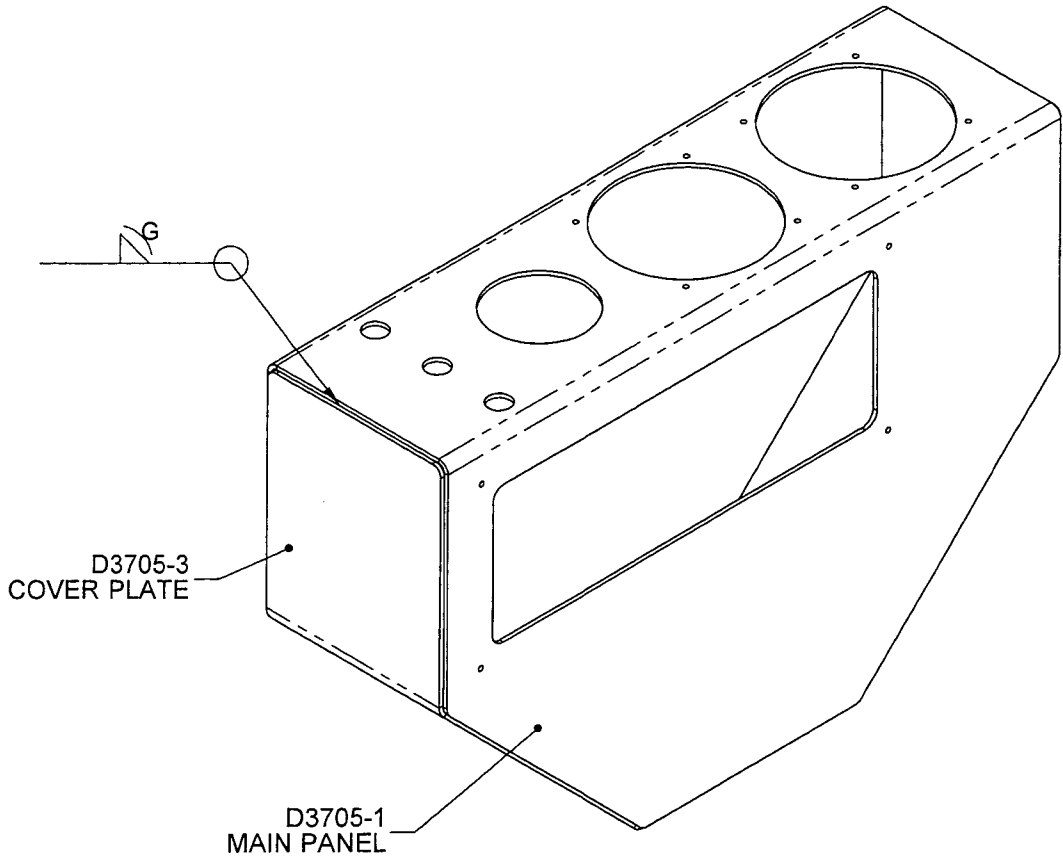
Product Name: VERTICAL REFERENCE DOOR

Requested By: MB

Design Manager Approval: _____

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3705-1F	MIAN PANEL	08.02.06	YES	ASAP	SEE BELOW	
1	D3705-3F	COVER PLATE	08.02.06	YES	ASAP	SEE BELOW	
1	D3705-041	INSTRUMENT PANEL	08.02.06	—	d	n	
						GIVE ALL W/Os AND PARTS TO D. STOW	

QTY -041	P/N	DESCRIPTION
X	D3705-041	INSTRUMENT PANEL
1	D3705-1	MAIN PANEL
1	D3705-3	COVER PLATE



D3705-041 INSTRUMENT PANEL

PRELIMINARY ISSUE

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.125)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 2.45 lbs
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.02.06
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3705	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL	1:3
DATE	08.02.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

